

Work Order ID 51620

August 27, 2009 8:27:18 AM



Page 1

Item ID: D350-636-012

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube RH

Start Date: 8/27/09 Start Qty: 1.00



Cust Item ID:

Required Date: 9/11/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

09-8-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100-

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 004

8/27/09

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end. 2-Drill pilot holes as per Dwg D2750 sheet 5 (D2750-2 details). Drill using drill Jig DT8150 & DT8863. 3- Mark fwd end for cutting using Drill Jig

A/R mill 899

3E 09/10/19
DP 9-10-19

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

27 8/27/09

(76)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2) ~~8~~ 8 on 10/19

70 6

1 ~~Ø~~ - Aug 9-10-20

1 ~~Ø~~ BE 9-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

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Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00



Skidtubes

1

Ø

AWM 9-10-20

Skidtubes

Memo

0.00

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750. 3-Open float holes to .500" (4 per Side). 4-Chamfer holes of Detail

AR M 11/999

BE 09/10/22

SEE ATTACHED SHEET - D

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

2) 8/21/23

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φ

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) 8/21/23

ⓧ

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

REFERENCE ONLY

B-51620

REFERENCE ONLY

SEQ 160

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side)

as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R

Sikaflex-291

batch:

M112391

exp. date:

10-02-20

AWM
9-10-20

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004

(welding instructions on sheet 9)

A/R

Aluminum Rod

batch:

M111999

06 9-10-22

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750

AWM
9-10-22

11- At section AJ-AJ drill out x-bolt spacer to 0.404"

12-Deburr holes

-AWM 9-10-22

REFERENCE ONLY

REFERENCE ONLY

B-24-10

13-0-00

13-0-00

13-0-00

13-0-00

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Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

10:30am

OVEN TEMPERATURE:

FINISH TIME:

320°

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

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Reference:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

Install inserts as per dwg D2750

MO 09/10/28

X1

230

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Inspect for Foreign Objects 12-Spray inside of tube with "LPS-3"

batch: MD 13-Install blade fitting D3488-042, wearshoes and ground
handling hardware as per dwg D2750
SIKA FLEX 2410 BATCH: M112391 EXP DATE: 10/20
assemble o'ri

LPS PROXYON: Batch: M104251

MD 09/10/28

X1

240

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

MD 09/10/28

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Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/10/28 10 SP

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

2) Skidtube

40 4

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-012

Loc to Rev C

9/10/28 12 SP

51620

W/O:		WORK ORDER CHANGES					
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Work Order ID 51620

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/02

W 9.10.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

August 27, 2009 8:27:17 AM

Page 1

19

Work Order ID: 51620

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2600-3-BENTRevD1

Manufactured

No

110

Each

0.0000

1.0000



352346 09/10/09

Extrusion Bent

D3532-1RevA

Manufactured

No

170

Each

43.0000

2.0000



Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

43

38161

2

44904

41

D2739RevD

Manufactured

No

160

Each

6.0000

1.0000



350 I Beam

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

4

50353

4

Main Warehouse

ST

2

47124

1

47681

1

B52321 SP

2 X SP

B-52305 AWM 9-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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August 27, 2009 8:27:17 AM

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Work Order ID: 51620



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 8/27/09

Required Date: 9/11/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2744RevC		Manufactured	No			160	Each	54.0000	1.0000			
Cap												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	54	
44892	19	
47488	35	

D3490-1RevA

Manufactured No

160 Each 165.0000 4.0000



Cross Bolt Spacer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	165	
45338	2	
47118	4	
47657	50	
48277	109	

1 BE 09/10/19

4 BE 09/10/22

August 27, 2009 8:27:17 AM

Shop Packet Print

Page 2

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Work Order ID: 51620

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Parent Item Name: Skidtube RH

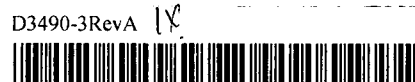
Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 1.00 ⁵

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3490-3RevA 		Manufactured	No			160	Each	112.0000	4.0000			
Cross Bolt Spacer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 112

45560 22

47471 35

48276 55

D2743RevB Manufactured No

220 Each 294.0000 8.0000



Crossbolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG 50

50281 50

Main Warehouse

ST 244

44891 2

45555 177

48275 65

4 25 09/10/22

8 80 09/10/22

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Shop Packet Print

Page 3

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Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-225		Purchased	No			230	Each	8,824.000	38.0000			



Insert

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

8824

107441

16

110768

8808

AN3C5A

Purchased

No

230

Each

650.0000

34.0000



Bolt

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

650

111424

8

111707

342

112314

200

112489

100

X38 mo 09/10/28

X34 mo 09/10/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3C6A Purchased No 230 Each 1,060.000 4.0000



BOLT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 1060

110372 84

111982 976

AN6C44A Purchased No 230 Each 172.0000 4.0000



BOLT

Warehouse Loc Qty Loc Code
Location

OFFSHORE

FG 2

103964 2

Main Warehouse

ST 170

110105 4

110155 14

110665 1

110865 51

111605 50

111649 50

112720

24 MD 09/10/28

24 MD 09/10/28

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AN8C35A		Purchased	No			230	Each	167.0000	1.0000			
												
BOLT												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	167	
102180	1	
106896	1	
110105	65	
110847	100	

AN960C10L

Purchased

No

230

Each

2,846.000

38.0000



washer

Warehouse Loc Qty Loc Code
Location

OFFSHORE

FG	100	
103585	100	

Main Warehouse

FP	-100	
112116	-100	

Main Warehouse

ST	2846	
112116	2846	

X1 MO 09/10/28

X38 MO 09/10/28

August 27, 2009 8:27:17 AM

Shop Packet Print

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Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C816L		Purchased	No			230	Each	330.0000	1.0000			
WASHER												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	330	
104093	2	
107520	4	
110139	29	
110372	36	
110584	100	
111424	159	

X1 mo 09/10/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:27:17 AM

Work Order ID: 51620

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH



Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2745RevB		Manufactured	No			230	Each	272.0000	8.0000			
												
Bushing												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	272
34817	2
36230	8
37303	1
39587	2
40726	2
41114	2
42778	19
43754	2
44893	37
45556	69
46695	18
<u>48278</u>	110

D3488-042RevB Manufactured No



Blade Fitting Assembly, RH

230 Each 9.0000 1.0000



X8 mp 09/10/28

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	9
29043	1
44531	8

52666

31 mp 09/10/28

August 27, 2009 8:27:17 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:27:17 AM

Work Order ID: 51620

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3492-041RevC

Manufactured

No

230

Each

3.0000

8.0000



Plug Assembly

51584

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

43816

3

3

230

Each

0.0000

8.0000

D3492-043RevC

Manufactured

No



Plug Assembly

52309

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

47523

11

11

D3535-25RevB

Manufactured

No

230

Each

11.0000

1.0000



Wearshoe

51603

X8 MD 09/10/28

~~X8 MD 09/10/28~~

X8 MD 09/10/28

X1 MD 09/10/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:27:17 AM

Work Order ID: 51620



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 8/27/09

Required Date: 9/11/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-25RevA		Manufactured	No			230	Each	21.0000	1.0000			



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

51607

ST

21

45569

1

47011

2

47526

8

50266

10

XL MD 09/10/28

D3537-1RevC

Manufactured No

230

Each

46.0000

3.0000



Wearpad

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

46

48288

3

50321

43

51624

XB MD 09/11/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:27:17 AM

Work Order ID: 51620

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3631-1RevA

Manufactured

No

230

Each

105.0000

8.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

105

38139

6

45353

16

47437

83

D3791-1RevA

Manufactured

No

230

Each

18.0000

1.0000



Wearplate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

47536

8

50269

10

51610

x8 mD 09/10/28

x1 mD 09/10/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:27:17 AM

Work Order ID: 51620

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH



Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-1RevA		Manufactured	No			230	Each	18.0000	1.0000			
												
Wearshoe												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

40551

47537

50231

18

1

4

13

230

Each

22.0000

1.0000

27 MD 09/10/28

D3793-3RevA

Manufactured No



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

47720

50216

22

11

11

27 MD 09/10/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:27:18 AM

Work Order ID: 51620

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3794-1RevA		Manufactured	No			230	Each	7.0000	1.0000			



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	516608	
ST	7	
46530	1	
47212	2	
47721	4	

Y1 MD 09/10/28

D3794-3RevA

Manufactured No

230

Each

27.0000

1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	27	
46531	2	
47440	2	
47722	11	
50240	12	

Y1 MD 09/10/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:27:18 AM

Page 14

Work Order ID: 51620

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-6		Purchased	No			230	Each	1,132.000	4.0000			



NUT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 1132

110584 34

111424 98

112314 1000

MS21083C8

Purchased

No

230

Each

92.0000

1.0000



NUT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 92

110584 5

111424 2

111637 21

112243 44

112492 20

xy mo 09/10/28

xi mo 09/11/28

August 27, 2009 8:27:18 AM

Shop Packet Print

Page 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:27:18 AM

Work Order ID: 51620

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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NAS1611-010

Purchased

No

230

Each

345.0000

8.0000



O-RING

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

345

110715

50

110915

295

NAS1611-013

Purchased

No

230

Each

320.0000

8.0000



O-RING

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

320

106513

11

111424

109

111758

200

(Handwritten signature)

X8 MD 09/10/28

W/O: 51620		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-10-28		Replaced O-Ring NAS 1611-010 By O-Ring D 2594-3 Batch: 52562 X8	MD	09-10-28	X8		

Part No: D 350-636-012 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:27:18 AM

Work Order ID: 51620

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 8/27/09


Required Date: 9/11/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN8C21A		Purchased	No			260	Each	112.0000	2.0000			

S 
BOLT

 9/10/08 SP

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	112
105160	1
107596	1
107924	2
109092	2
110341	2
110342	4
111605	50
111684	50

AN960C816L

Purchased

No

260

Each

330.0000

2.0000

S 
WASHER

 9/10/08 SP

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	330
104093	2
107520	4
110139	29
110372	36
110584	100
111424	159

2 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:27:18 AM

Work Order ID: 51620

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2741RevC  Blade, 350 Skidtube		Manufactured	No			260	Each	40.0000	1.0000			

9/10/09 SP

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

40

20770

0

45320

1

47113

39

260

Each

115.0000

2.0000

1 50

D3493-1RevA

Washer

Manufactured

No

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

115

44902

15

47710

100

2 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:27:18 AM

Work Order ID: 51620

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8  NUT		Purchased	No			260	Each	92.0000	2.0000			

9/10/20 SP

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	92	
110584	5	
111424	2	
111637	21	
112243	44	
112492	20	

230

NAS1515H3L

Purchased

No



WASHER

260
230

350.0000 4.0000



Warehouse Loc Qty Loc Code
Location

OFFSHORE

FG	40	
102472	40	

Main Warehouse

ST	310	
110450	2	
110806	8	
111819	300	

24 MD 09/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action ~ Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:27:18 AM

Work Order ID: 51620

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H8L		Purchased	No			260	Each	129.0000	2.0000			



WASHER



91068 sf

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	129	
107581	34	
108964	1	
111650	94	

2 sf

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

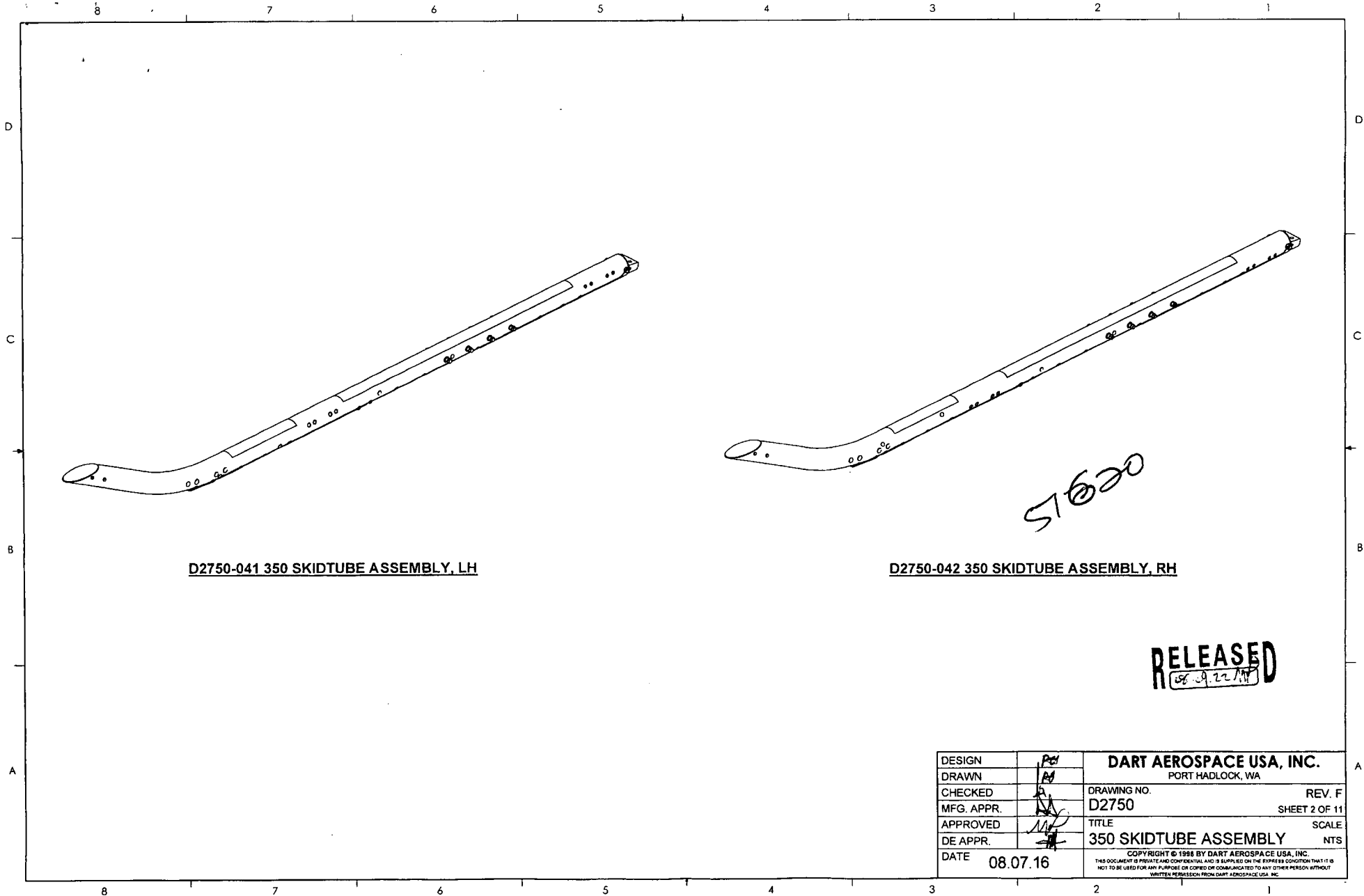
GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3781-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC.	
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CHECKED	AS	DRAWING NO.	REV. F
MFG. APPR.	AS	D2750	SHEET 1 OF 11
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	350 SKIDTUBE ASSEMBLY	NTS
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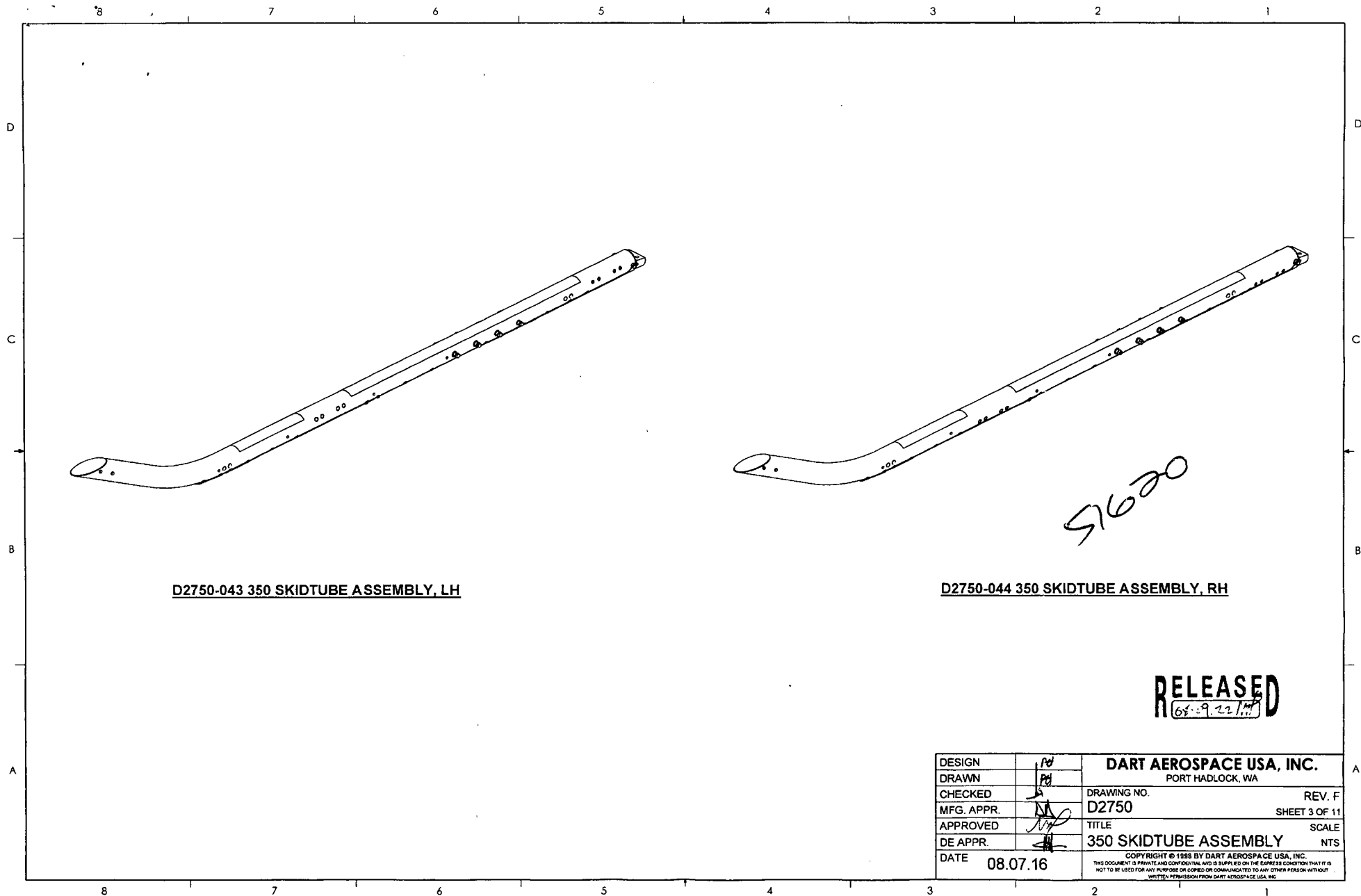


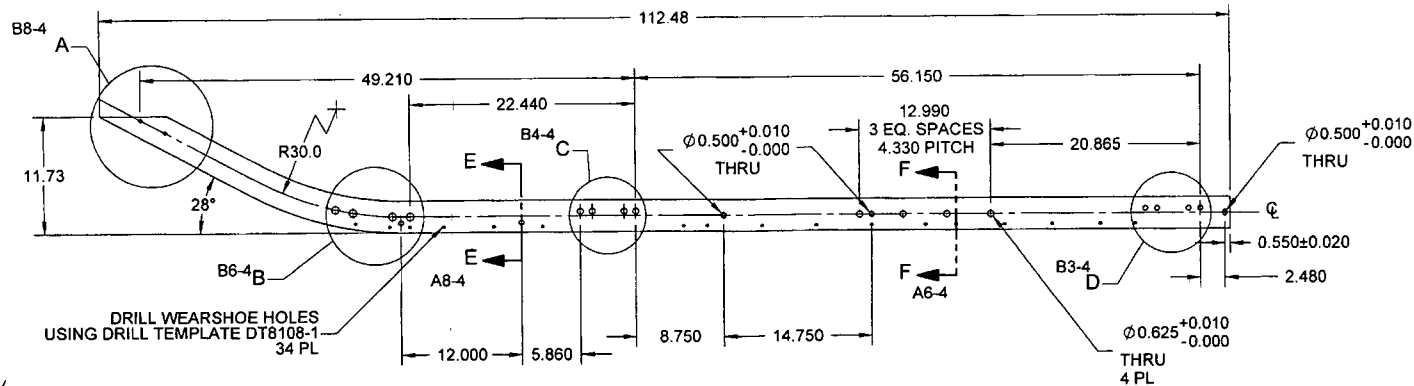
D2750-041 350 SKIDTUBE ASSEMBLY, LH

D2750-042 350 SKIDTUBE ASSEMBLY, RH

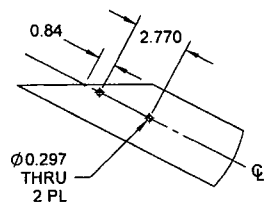
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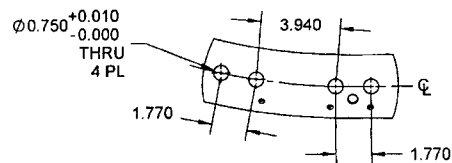




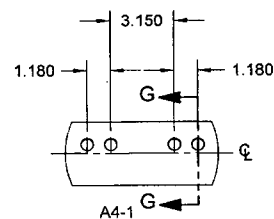
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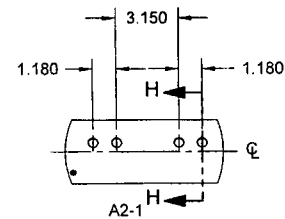
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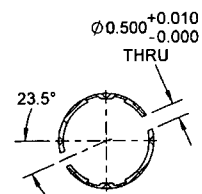
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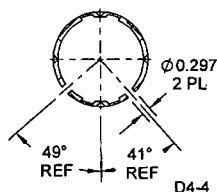
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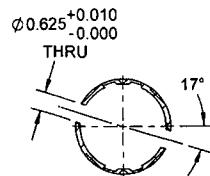
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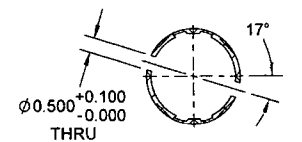
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

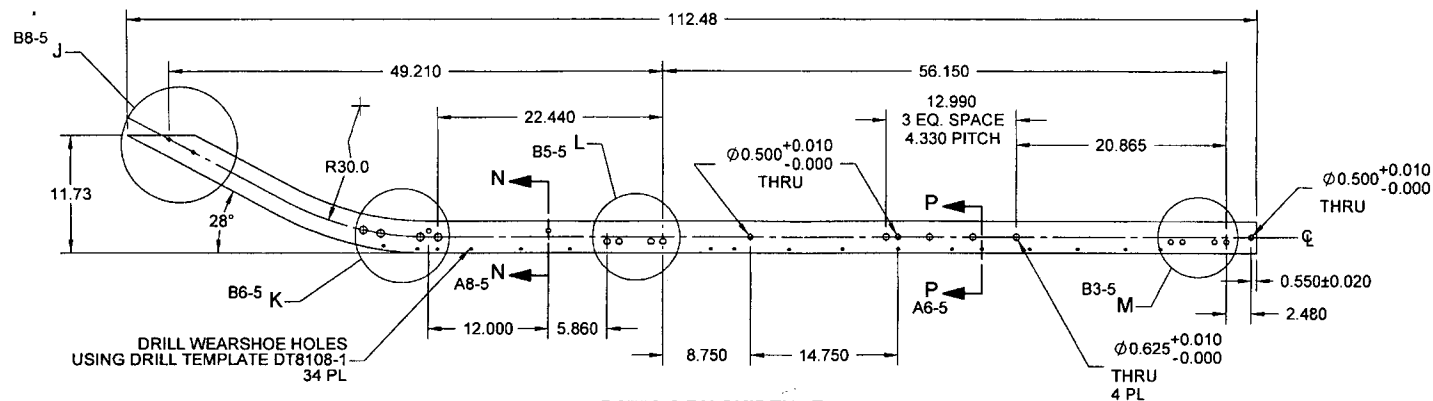


SECTION H-H
SCALE 3X, 4 PL

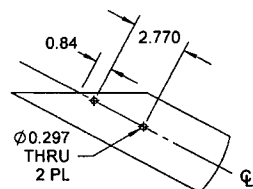
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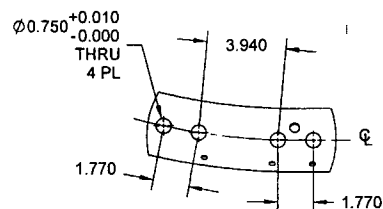
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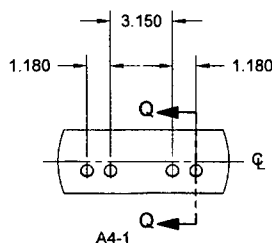
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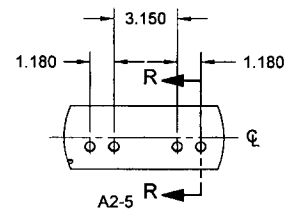
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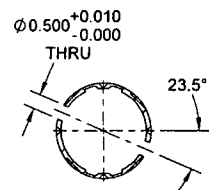
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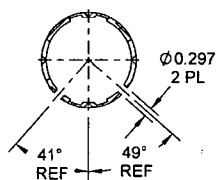
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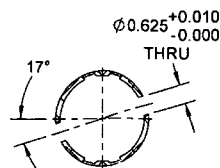
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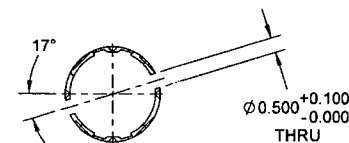
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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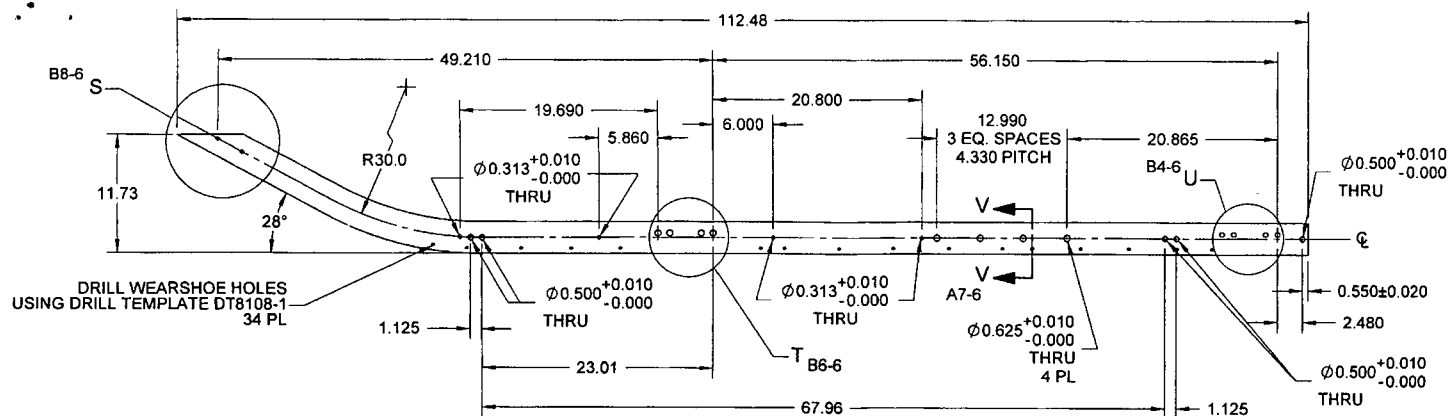
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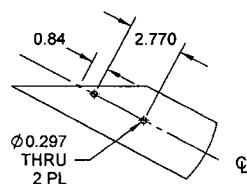
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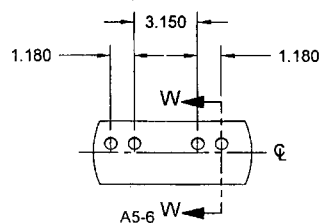
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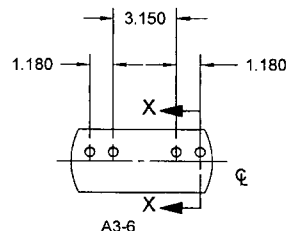
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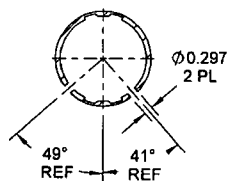
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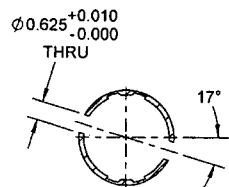
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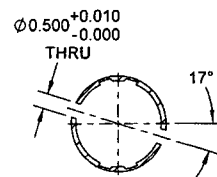
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

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8

7

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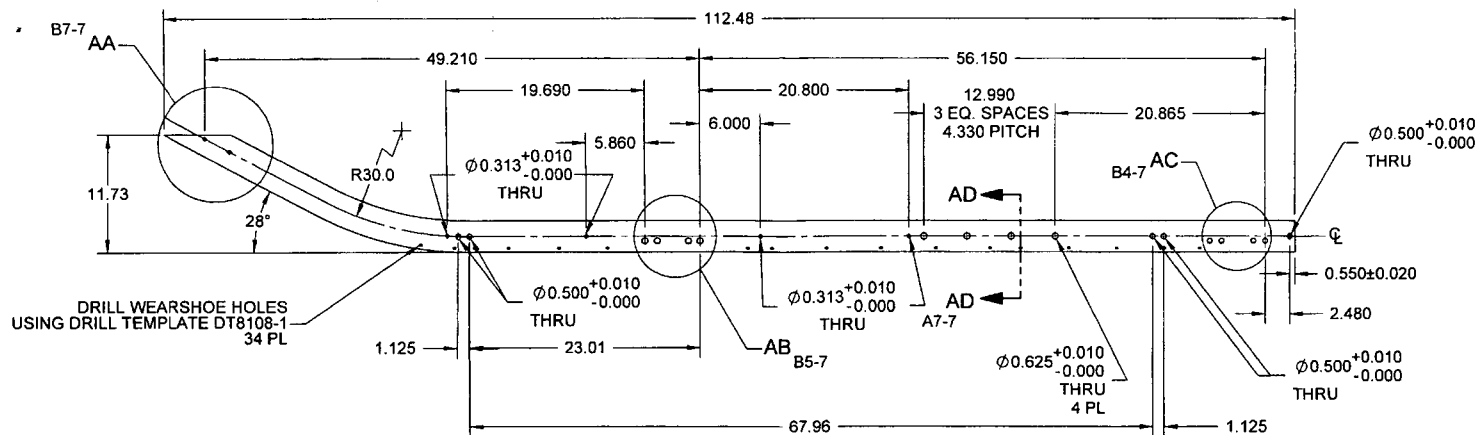
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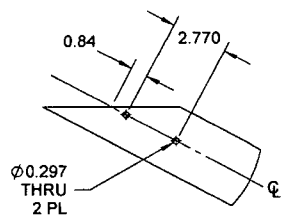
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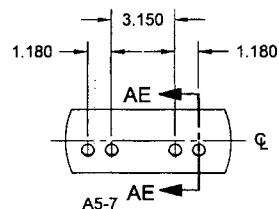
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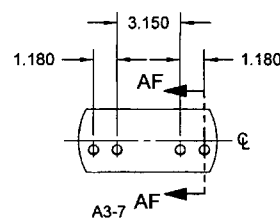
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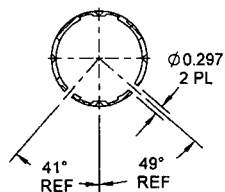
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SCALE 2X



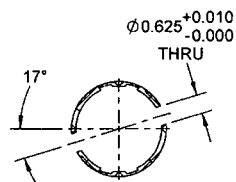
DETAIL AB
SCALE 2X



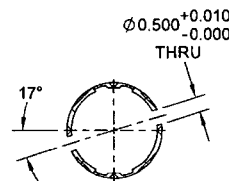
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL







SECTION AE-AE
SCALE 3X, 4 PL

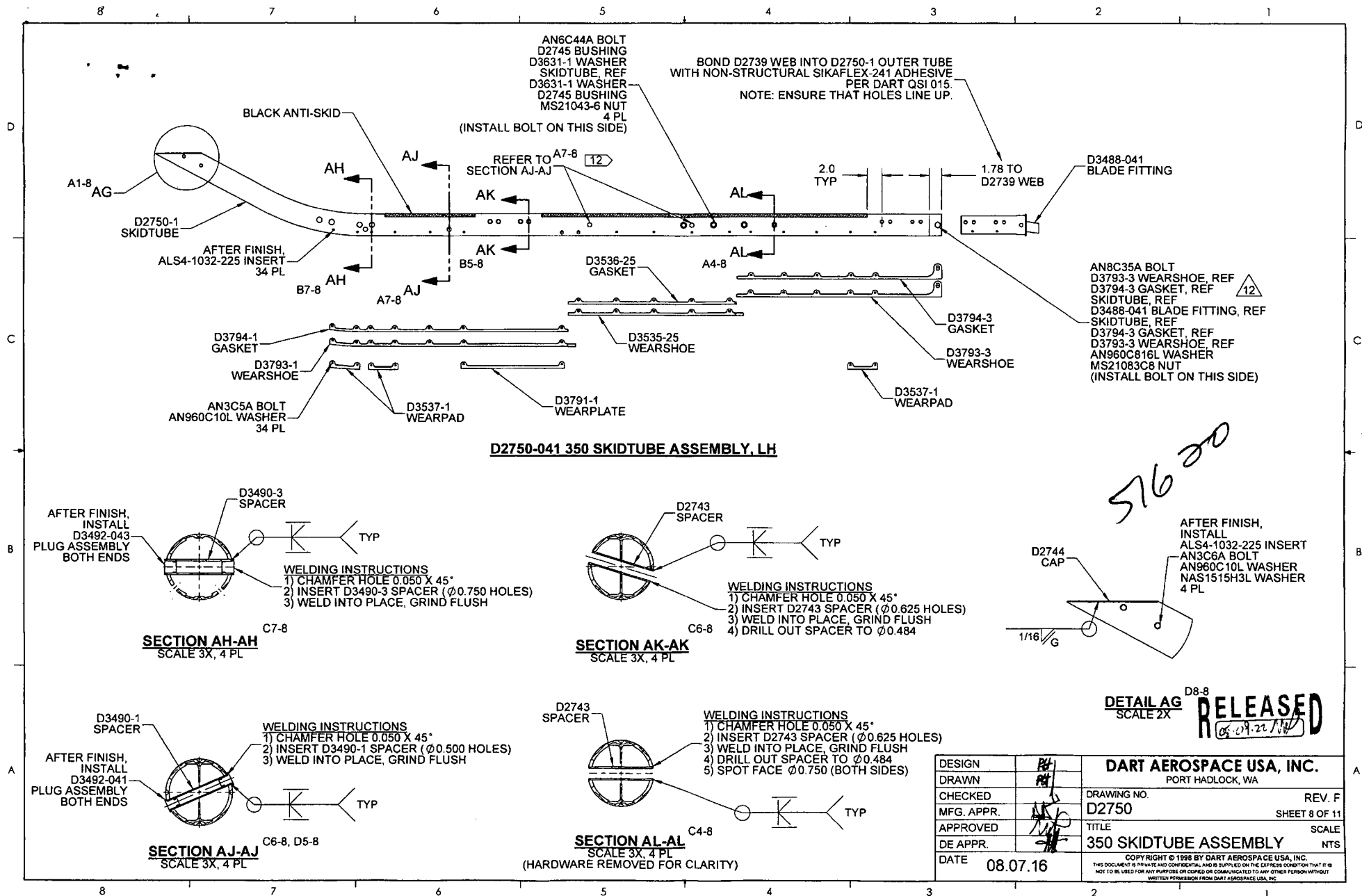


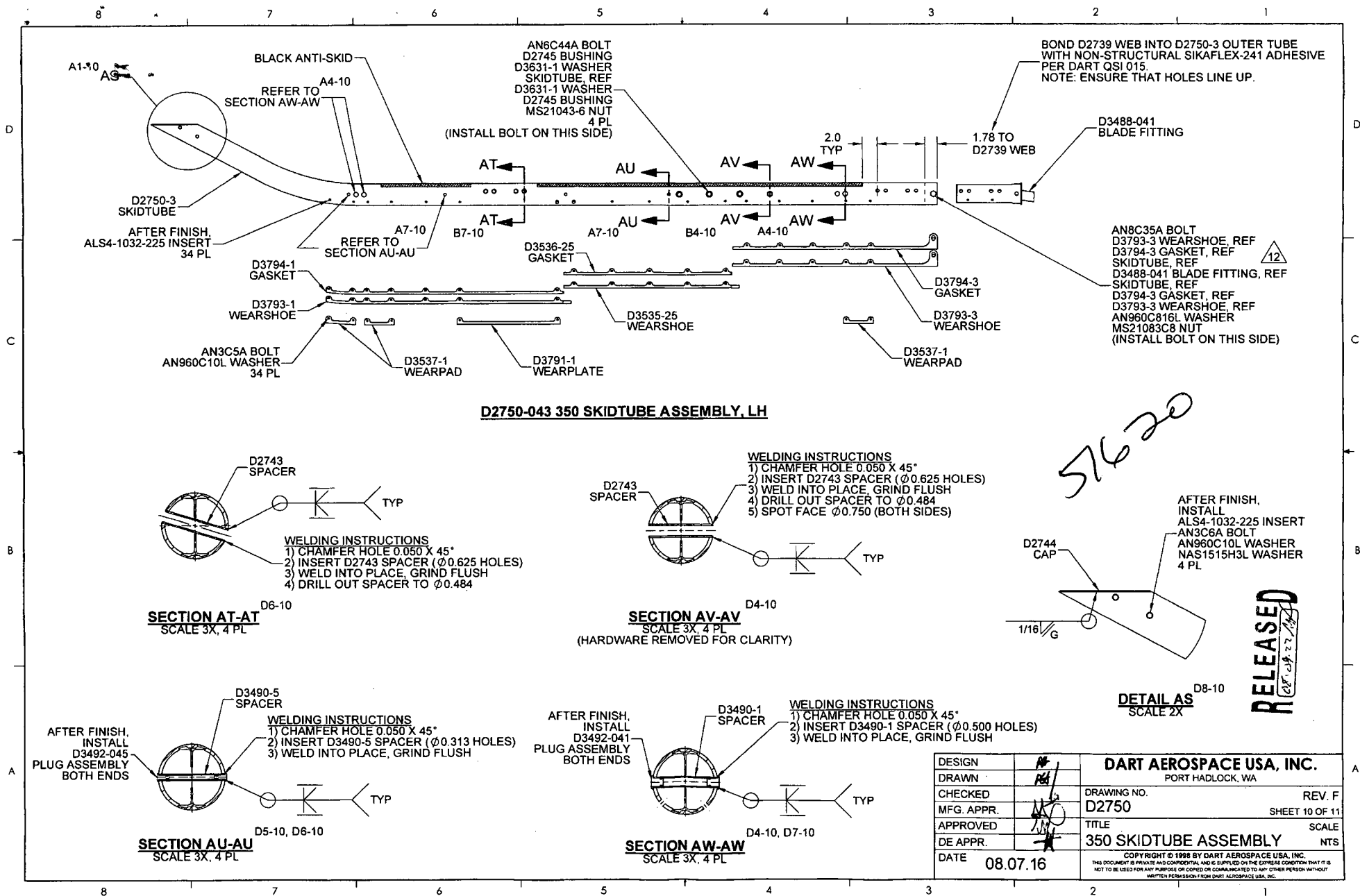
SECTION AF-AF
SCALE 3X, 4 PL

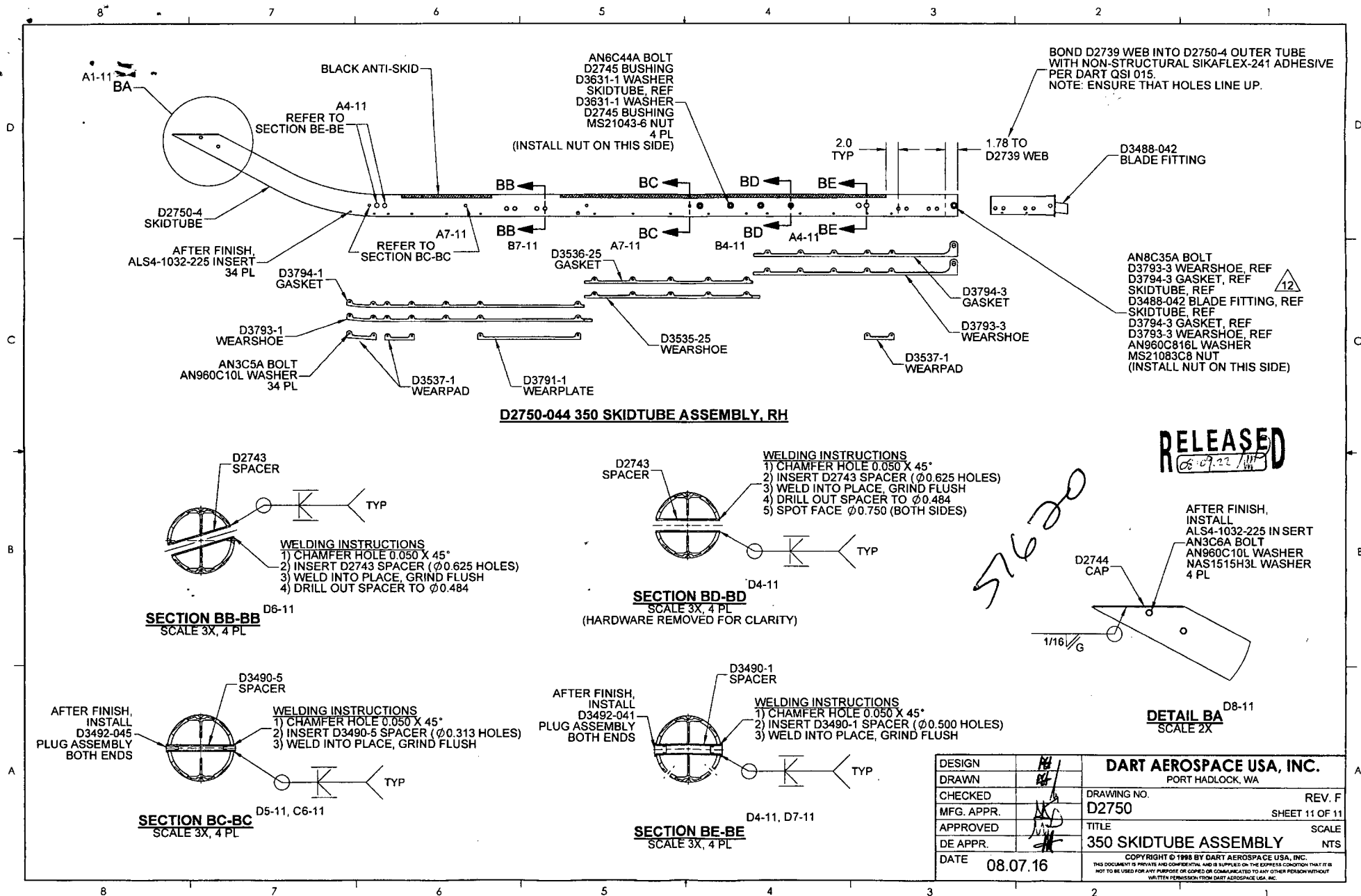
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NO. 213

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: B51620
Part number: 1350-636-Q12
Description: 350 Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David David Date of Test Coupon 09/10/22
Welder Barclay Elliott Date of Test Coupon 09/10/22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld